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6608

C45-8-2
Job Sheet 185258



Part No: C45-8-2

Job Qty: 2 ea

Part Name: Solenoid



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/24/18

Job Tracking No:

Due Date: 11/9/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: C45-8-2 REV.5 IPP REV:A 18.02.07 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	11/9/18	11/9/18	0.00	0.00	Start Up Small Fab-4		SB 18/11/21
100	Small Fab	2 pcs	11/9/18	11/9/18	0.08	0.10	Small Fab-9		AP DAS 38
110	QC	2 pcs	11/9/18	11/9/18	0.00	0.00	QC5		38
130	Packaging	2 pcs	11/9/18	11/9/18	0.00	0.00	Packaging3-2		3-88
140	QC21-FG	2 Ea	11/9/18	11/9/18	0.00	0.00	QC21		DAS 21 3-88

Part Op 100 - 1-Assemble as per DWG sheet 1. 2-Center C45-8-3 in shaft of solenoid as per note 1. ***Note 32446 22-16 crimp
Descriptions: connectors supplied loose as per note 1***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
32446	Crimp Terminal	4 Ea (2 ea)	90-Start up Operation	5089148
C45-8-2-4	Spacer	2 Ea (1 ea)	100-Small Fab	5119133
C45-8-2S	Solenoid	2 Ea (1 ea)	100-Small Fab	5120194
C45-8-3	Split Pin	2 pcs (1 ea)	100-Small Fab	5105619

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	32446	4	195	0
100-Small Fab	C45-8-2-4	2	19	0
	C45-8-2S	2	0	0
	C45-8-3	2	100	0



Container No: S130297



Part: C45-8-2

Job No. 185258

Serial No/Batch: S130297

Revision: 5

Inspector:

Exp Date:

Instructions:

Date: 11/21/18

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und.

Plex 10/24/18 11:36 AM Dart.lajeunesse.marie

WORK ORDER NON-CONFORMANCE / UPDATE

_____ Date: _____

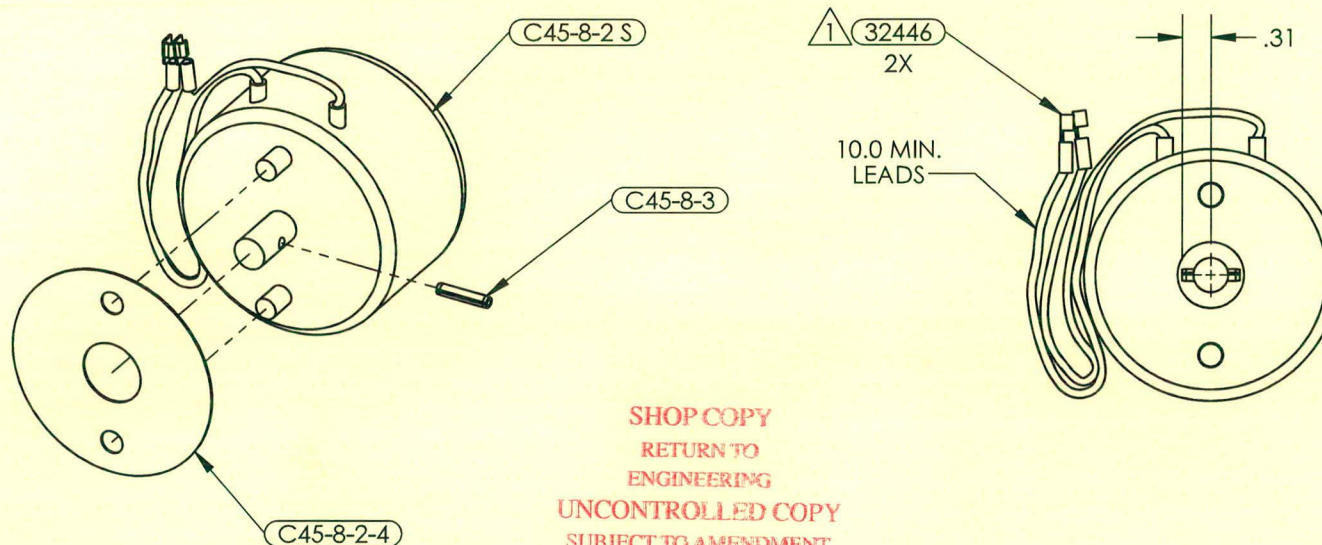
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
										QC / QA Coordinator Approval															
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2		AS DRAWN BY CANAM.	7/29/2014	JAG	
3		ADDED SPACER C45-8-2-4.	7/29/2014	RJC	DW
4	14-0099	CH'D TITLEBLOCK WAS RED BARN IS DART. ADDED MCMASTER-CARR INFO FOR C45-8-3, CORRECTED BO INFO FOR C45-8-2-4 WAS Ø1.75 IS Ø2-5/8. ADDED DIM .31. ADDED CONNECTORS SUPPLIED LOOSE NOTE. CH'D P/N WAS C45-8-2 IS C45-8-2 S. C45-8-2 S CH'D DIMENSION FROM .340 TO 11/32. CH'D TOLERANCE ON NON-CRITICAL DIMENSIONS.	7/29/2014	JAG	RW
5	15-0221	C45-8-2-5 REPLACED WITH 32446.	8/24/2015	DPD	JAG



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WORK ORDER
NO. 185258 MJS
18-1024

NOTE:

1 CONNECTORS SUPPLIED LOOSE.

DART AEROSPACE	
TITLE SOLENOID C45-HOOK	
DWG NO. C45-8-2	REV 5
MAT'L	DRAWN BY:
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .005 FRACTIONS ± 1/8	
.XX ± .01 ANGLES ± 5°	
.X ± .1	
1. BREAK ALL SHARP EDGES .015 x 45°	
OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:2	DATE
SHEET 1 OF 3	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			C45-8-2 S	1	SOLENOID		TESTCO H-2553-020 (MODIFIED)	2
			C45-8-2-4	1	SPACER	PETG	Ø2-5/8 X .020	3
		B/O	C45-8-3	1	SPLIT PIN	18-8 S.S.	Ø1/8 X 5/8 (MCMASTER-CARR #92373A179)	1
		B/O	32446	2	22-16 AWG KNIFE CONNECTOR		(ALLIED ELECTRONICS 32446)	1

